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guides. A controlled amount of the specially formulated two part expandable polyurethane foam is injected into to the void **10** created by the outer (paper ring) and the center dowel. The second or top sidewall **4** is put in place as the foam begins to expand and fill the void, which becomes a closed compartment created by the positioning of the second sidewall or flange. The dowels form a continuous void through the reel as the foam sets. The continuous void is present in the sidewalls and the core.—

IN THE CLAIMS:

Please cancel claims 1 through 21 of the prior application.

Please enter the following claims:



A method of producing a reel for packaging, comprising the steps of:

- a. forming a first sidewall and a second sidewall;
- b. placing a partition having a void therein of a generally circular cross section, adjacent to, and generally concentrically with, said first sidewall, wherein a perimeter of said first sidewall extends beyond an outside perimeter of said partition;
 - c. filling said void of said partition with a flowable material;
- d. placing said second sidewall in a generally parallel and concentric relationship with said first sidewall and against said partition;
- e. allowing said flowable material to cure, wherein said flowable material forms a solid core, and adheres to said first sidewall and said





second sidewall, thereby connecting said first sidewall to said second sidewall.

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A method of producing a reel for packaging as described in Claim 24, further comprising the step of forming at least one void in said solid core.

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A method of producing a reel for packaging as described in Claim 26, further comprising the steps of placing a second partition within said outside perimeter of said partition, and filling a void that is present between said outside perimeter of said partition and an outside perimeter of said second partition with said flowable material.

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A method of producing a reel for packaging as described in Claim 2, wherein said first sidewall is generally circular and is generally concentric with said partition, and wherein said outside perimeter of said partition is generally circular.

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A method of producing a reel for packaging as described in Claim 26, wherein said first sidewall is generally circular and is generally concentric with said partition, and wherein said outside perimeter of said partition is generally circular.

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A method of producing a reel for packaging as described in Claim 24, wherein said first sidewall is generally circular and is generally concentric with said partition, and wherein said outside perimeter of said partition is generally circular.

A method of producing a reel for packaging as described in Claim 2, wherein said partition is formed of paper.

A method of producing a reel for packaging as described in Claim wherein said first sidewall is formed of paper.

A method of producing a reel for packaging as described in Claim 22, wherein said partition is formed of corrugated material.

A method of producing a reel for packaging as described in Claim 2/2, wherein said first sidewall is formed of corrugated material

The reel for packaging produced by the method of Claim 22.

The reel for packaging produced by the method of Claim 28.

The reel for packaging produced by the method of Claim 24.

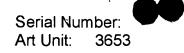
The reel for packaging produced by the method of Claim 26.

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The reel for packaging produced by the method of Claim The reel for packaging produced by the method of Claim

The reel for packaging produced by the method of Claim 🎉

The reel for packaging produced by the method of Claim 26.

The reel for packaging produced by the method of Claim 36.

The reel for packaging produced by the method of Claim 2

Respectfully submitted,

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